Work Order ID 70532 -

Friday, June 10, 2011 11:44:52 AM

Quality Control



Page 1

Item ID: D3463-041 Accept Setup Start Revision ID: Stop Step Weldment Assembly Item Name: Start Qty: 4.00 Start Date: 6/10/2011 Cust Item ID: Required Date: 6/15/2011 Reg'd Oty: 4.00 Customer: Reference: Start Run Date: //-00/0 Tooling: Approvals: Process Plan: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description Code Qty Otv Number Stamp **Run Hours** Draw Nbr Revision Nbr D3463 Rev B 0.00 E 11-7-6 Large Fab Large Fab 0.00 Memo Large Fab Weld assembly as per dwg D3463 using DT8875 110 QC9- Inspect visual per QSI004- Fusion Welds 0.00 Gan.07.06 0.00 Memo Quality Control 120 OC5- Inspect part completeness to step on W/O Sulor los QC Memo

W/O:			V	ORK ORDER CHANGE	S					
DATE	STEP	PROC	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									Prod Mgr	
Part No:		PAR #:	_ Fault Ca	tegory:	NCR:	: Yes N	o DQ	A:	_ Date: _	
	R	esolution:	Disposit	ion:	QA: I	N/C Clos	ed:		Date: _	
NCR:		W	ORK OR	DER NON-CONFORMA	NCE	(NCR)				
DATE	STEP	Description of NC		Corrective Action Section			Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	1	on C	Chief Eng	QC Inspector
D										
				Ti di						

Work Order ID 70532

Friday, June 10, 2011 11:44:52 AM



Page 2

Item ID:

D3463-041

Accept

Setup

Start

Stop



Revision ID:

Item Name:

Step Weldment Assembly

Start Date:

Required Date: 6/15/2011

6/10/2011

Start Oty: 4.00

Reg'd Oty: 4.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date: Date: Tooling:

SPC (Y/N):

Date: Date:

Start Run

Stop



OC:

Sequence ID/ Work Center ID

130

Operation Description

White Gloss(Ref.4.3.5.2) per QSI005 4.3-Steel

Set Up/

Run Hours

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

Powdercoat

Powder Coating

1- Mask areas indicated on dwg D3163 (holes, threads) START TIME: OVEN TEMPERATURE:

0.00

FINISH TIME:

140

HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch

Memo

0.00

BY 11-7-7.

150

QC3- Inspect Part Finish

Memo

0.00

Quality Control

0.00

W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:						Date:	
NCR:		V	VORK ORI	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DAIL	O I L	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
v ç									

Work Order ID 70532

Friday, June 10, 2011 11:44:52 AM



Page 3

Item ID:

D3463-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Start Date:

Step Weldment Assembly

Required Date: 6/15/2011

6/10/2011

Start Qty: 4.00

Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date: Date:

Tooling:

SPC (Y/N):

Date: Date: Run

Start

Stop

Sequence ID/

Work Center ID

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location

Memo

Set Up/ Run Hours

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

170

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

		14/6		_				
		WC	ORK ORDER CHANGE	S				
STEP	PRO	OCEDURE CHA	CEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
	71							
	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
Res	solution:	Dispositio	n:	QA: N/C C	losed:		Date: _	
		WORK ORD	ER NON-CONFORMAI	NCE (NC	₹)			
CTED	Description of NC			Verifi	cation	Approval	Approva	
SIEF	Section A	Initial Chief Eng	Action Description Chief Eng			Section C Chief Eng		QC Inspecto
		PAR #:	PAR #: Fault Cate Resolution: Dispositio WORK ORD STEP Description of NC Section A Initial	PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORMAN STEP Description of NC Section A Corrective Action Section Initial Action Description	PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C C WORK ORDER NON-CONFORMANCE (NCI STEP Description of NC Section A	PAR #: Fault Category: NCR: Yes No DQ Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	PAR #: Fault Category: NCR: Yes No DQA: Date: NCR: Yes No DQA: Date: NCR: Disposition: QA: N/C Closed: Date: NCR: Date: NCR: Date: Disposition: QA: N/C Closed: Date: Date: NCR: Date: Date: Date: Disposition: QA: N/C Closed: Date: Date: Date: Description of NC

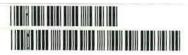
Friday, June 10, 2011 11:44:58 AM

Work Order ID: 70532

Parent Item:

D3463-041

Parent Item Name: Step Weldment Assembly



IPP revB: replace pressure

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

00	mп			
t o	пп	ıen	18:	

IPP REV. A 05.11.18 new issue

with wing walk DD 10.01.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-866 SS DOWEL PIN 1" LONG		Purchased	No			100	Each	92.0000	2	8 Z	11-	7-4.	
				Location	a	Loc		Loc Code					
				ST	117606		92 92		-	8			
)3453-3 	1011	Manufactured	No			100	Each	0.0000	1	4		4. 5	
Clevis					70854X	4				a	11-7-	4 -	1
03453-5	100.000	Manufactured	No			100	Each	15.0000	1	4			
Plug										R	11-7-	4.	
				Location		Loc	Qty	Loc Code					
				WA023	59204		15 15		-	4	_		
03463-1		Manufactured	No			100	Each	0.0000	1	4			
* 				69	948 X 4	_				A	11	-7-4	
03463-3		Manufactured	No		1 - 1 - 1	100	Each	26.0000	1	4			
Giep										A	11-	7-6	
				Location	Į.	Loc	Qty	Loc Code					
				WA025			26				_		

26

W/O:			V	VORK ORDER CHANGE	S					
DATE	STEP	PRO	CEDURE CH	IANGE	Е	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									Prod Mgr	
Part No:	·	PAR #:	_ Fault Ca	tegory:	NCR:	Yes N	o DQ/	A:	_ Date: _	
	R	esolution:	_ Disposit	ion:	QA: N	/C Clos	ed:		Date:	
NCR:		ORK OR	DER NON-CONFORMA	NCE (NCR)					
DATE	STEP	Description of NC		Corrective Action Section	544.03		Verific	ation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
										1
NOTE D										

Picklist Print

Friday, June 10, 2011 11:44:58 AM

Page 2

Work Order ID: 70532

Parent Item:

D3463-041

Parent Item Name: Step Weldment Assembly



Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

D3463-5

End Cap

Manufactured No 100

100

Each

13.0000

2

EL 11-7-6

D3463-7

Manufactured No Location 58928 Loc Qty 1.3 13 Each Loc Code 3.0000

EL 11-7-6

Drag Arm

Location

Loc Qty

Loc Code

W/O:			W	ORK ORDER CHANGE	S					
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					×					
Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes No	DQA	\:	_ Date: _	
	R	esolution:	Dispositio	n:	QA: I	V/C Clos	ed:		Date:	
NCR:		V	VORK ORD	ER NON-CONFORMA	NCE	(NCR)				
DATE	STEP	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
1						1				



INSTALL P/N 238-806

DESIGN RF	DRAWN BY RF	DART AEROSPAC HAWKESBURY, ONTARIO,			
CHECKE	APPROVED #	DRAWING NO.	REV. B SHEET 1 OF 4		
DATE	05.12.05	STEP WELDMENT	SCALE 1:8		
Α	05.09.20	NEW ISSUE			
В	05.12.05	REVISE DIM.: D3463-5 WAS D34	D3463-5F		

150°

DOWEL PIN 1/G MASK THREAD AREA 1.045 -



D3463-5 END CAP

(2 PLACES)

1/G

ENGINEERING UNCONTROLLED COPY

RELEASED SUBJECT TO AMENDMENT 05 42 09 WITHOUT NOTICE WORK ORDER D3453-3 CLEVIS B 0.10 9.100+0.010 (TYP) 90 D3463-7 DRAG ARM INSTALL SPAENAUR 45° P/N 238-806 DOWEL PIN D3463-1 ARM (1) WING WALK TOP SURFACE 0.10 0.30

D3463-042 STEP WELDMENT ASSEMBLY D3463-041 OPPOSITE

D3463-3 STEP

NOTES:

D3453-5 PLUG

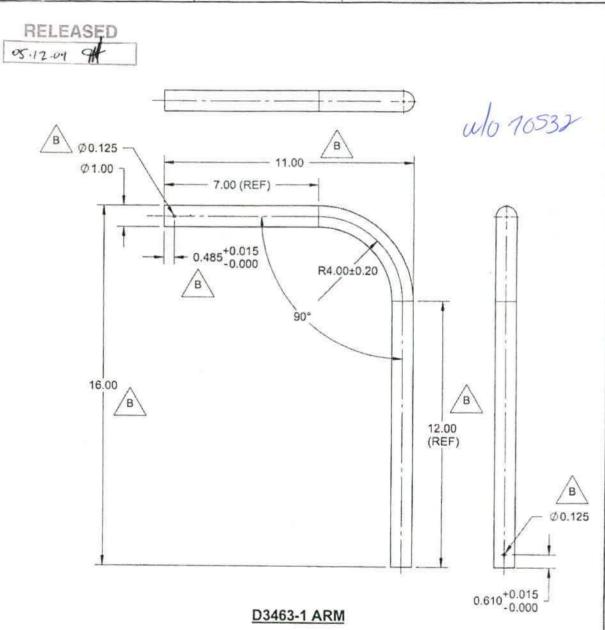
- 1) WELD PER DART QSI 004
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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Dail Aci	OSPACE	Liu							
W/O:			WC	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC-Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Dispositio	n:	QA: N/C CI	sed:		Date: _	
NCR:		\	WORK ORD	ER NON-CONFORMAI	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section	10.00	Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector



DESIGN RF	DRAWN BY RF	DART AEROSPAC HAWKESBURY, ONTARIO	
CHECKED	APPROVED	DRAWING NO.	REV. B SHEET 2 OF 4
DATE 05.1	12.05	STEP WELDMENT	SCALE 1:4



NOTES:

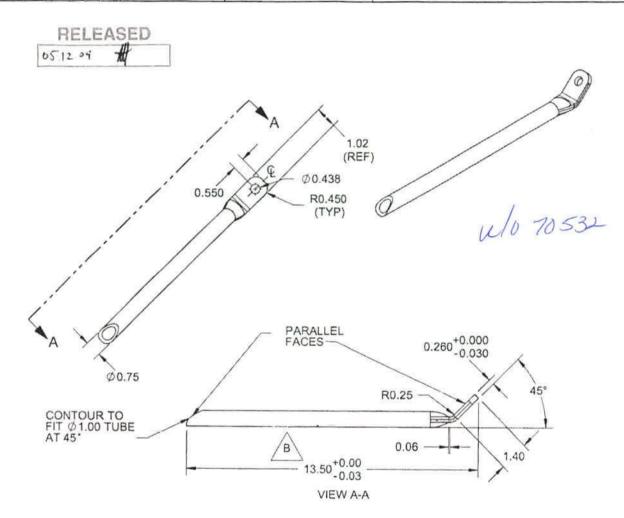
- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120) 2) FINISH: NONE 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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Dail Aci	ospaoc	Ltu							
W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	Date:	
		esolution:							
NCR:		V	VORK ORE	DER NON-CONFORMA	NCE (NCR)			
		Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC Inspector



DESIGN	DRAWN BY RF	DART AEROSPAC HAWKESBURY, ONTARIO	
CHECKED	APPROVED	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.	12.05	STEP WELDMENT	SCALE 1:4



D3463-7 DRAG ARM

NOTES:

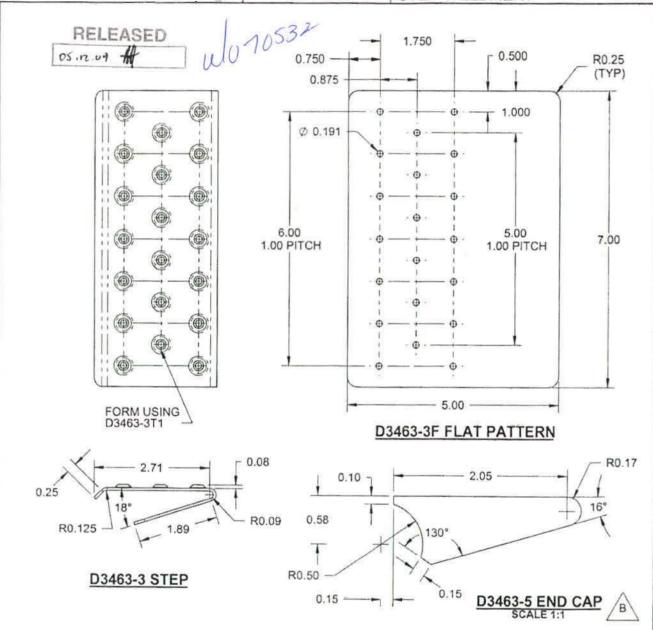
- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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	WHEN PROPERTY.								
W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Categ	gory:	NCR: Yes No DQA:			_ Date: _	
Resolution:			Disposition	QA: N/C CI	osed:	Date:			
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification		Approval	Approval
			Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED	APPROVED	DRAWING NO.	REV. B SHEET 4 OF 4			
DATE 05.	12.05	STEP WELDMENT	SCALE 1:2			



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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Dail Ac	Ushace	Liu								
W/O:			WC	RK ORDER CHANG	ES					
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		*						_		
		- E								
Part No: PAR #:		PAR #:	Fault Cate	NCR: Yes	NCR: Yes No DQA: Date:					
Resolution:			Disposition	QA: N/C CI	QA: N/C Closed: Date:					
NCR:		V	VORK ORDE	ER NON-CONFORMA	NCE (NCF	?)				
DATE	STEP	Description of NC Section A		on B	Verific	ication	Approval	Approval		
			Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector	
			*							